



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

649.4811
Job Sheet 186016



Part No: 649.4811

Job Qty: 4 ea

Part Name: Clip



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/8/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: 649.4800 REV.E IPP REV.A 12.11.01 NEW ISSUE DD VERF:JLM IPP REV:B 17.10.18 AS PER DWG REV.D DD VERF:JFS IPP REV.C 18.03.14 AS PER DWG REV.E DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	4 pcs	11/23/18	11/23/18	0.00	0.05	Waterjet - Flow		SC 18/11/18
120	QC	4 pcs	11/23/18	11/23/18	0.00	0.00	QC2 Waterjet-1		SC 18/11/18
130	QC	4 pcs	11/23/18	11/23/18	0.00	0.00	QC8-1		38
140	Brake NC	4 pcs	11/23/18	11/23/18	0.00	0.10	Brake NC 1		DAS 18/11/18
150	QC	4 pcs	11/23/18	11/23/18	0.00	0.00	QC5		38
160	Outsource	4 pcs	11/23/18	11/23/18			ATG001-VC	10	DEC 18 2018
170	Packaging	4 pcs	11/23/18	11/23/18	0.00	0.00	Packaging2		DEC 18 2018
180	QC	4 pcs	11/23/18	11/23/18	0.00	0.00	QC6		61
210	Packaging	4 pcs	11/23/18	11/23/18	0.00	0.00	Packaging3-1		9-89
220	QC21-SA	4 Ea	11/23/18	11/23/18	0.00	0.00	QC21		9-89

Part Op 110 - 1-Cut as per Dwg Dwg Rev: E Prog Rev: E 2-Deburr if necessary
Descriptions: 160 - Issue P/O to ATG: 000 91855 AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required
210 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	.2720 sf (.068 ea)	110-Waterjet - Flow - 1	5101738

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M2024T3S.063	0	115	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
DART Aerospace Ltd. 1270 Aberdeen Street Haverhill, ON K6A 1K7 TEL: 613 832-5200 Email: sales@dartaero.com www.dartaero.com Container No: S126915 Part: 649.4811 Job No: 186016 Serial No/Batch: S126915 Revision: E Inspector: Exp Date: Instructions: Date: 11/12/18		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
CATEGORY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence					

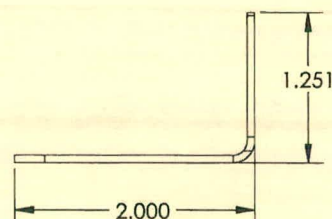
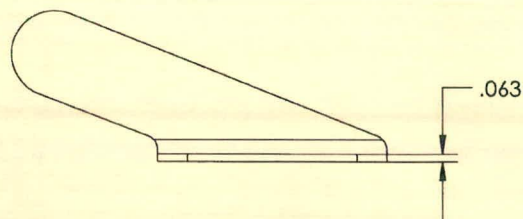
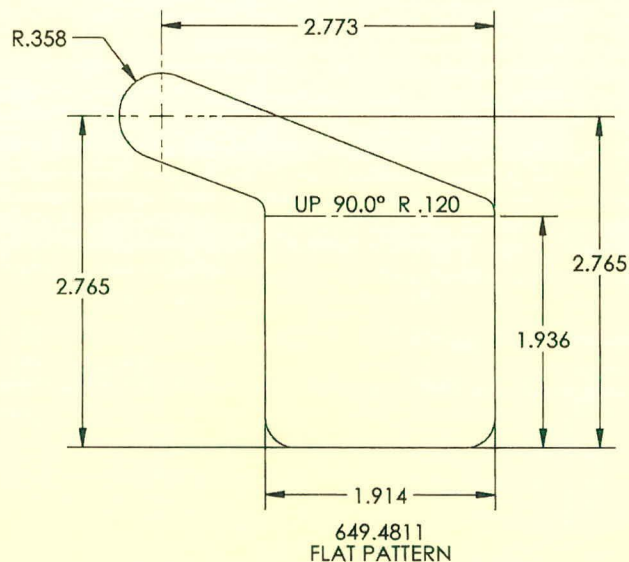
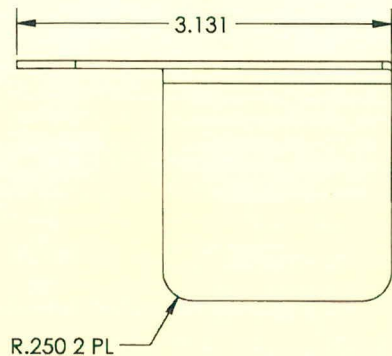
Handling: _____ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Use for testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Instructions Incomplete/Unclear ☐ Drill Holes ☐	OTHER : _____
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ADP 1.1 2018

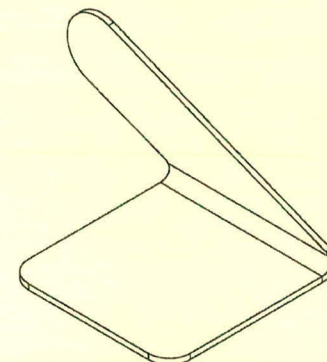
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NOTES: UNLESS OTHERWISE SPECIFIED

- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120. LASER ETCH P/N AND REVISION 12PT. CENTURY GOTHIC.
- 5 PART DIMENSIONS CONTROLLED BY CAD MODEL; FILE NAME: 649.4816 DOUBLER.SLDPR
6. INSPECTION DIMENSIONS SHOWN WITH FINISH APPROX. 3-5 MIL MAX PER FACE.



REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
N/C	LAST PROTOTYPE REVISION: P02		
A	INITIAL RELEASE	11-02-11	P. BRAVO
A	INCORPORATED ECH 03475	04-11-12	P. BRAVO



649.4811

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 186016 *MW*
1811-08

	7	649.4816	DOUBLER	△	△	△
	6	649.4815	SHIM	△	△	△
	5	649.4814	DOUBLER	△	△	△
	4	649.4813	SHIM	△	△	△
	3	649.4812	SHIM	△	△	△
	2	649.4811	CLIP	△	△	△
	1		DELETED			
	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.	
QTY						
NEXT ASSY (S)			ORIGINAL DATE 11-02-11 DRAWN BY A. QUAN CHECKED BY P. BRAVO DRAWING APPROVAL P. BRAVO 11-02-11 CONTRACT NO. UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°			
649.4700						
			PARTS LIST APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300 SHEETMETAL			
			SIZE	CAGE CODE	DWG. NO.	REV.
			B	07M26	649.4800	A
			SCALE NONE		SHEET 1 OF 5	

Linda Lacelle

From: Linda Lacelle
Sent: Wednesday, November 7, 2018 11:21 AM
To: Patrick Duval; Caitlin Crooks
Cc: Jason Leroux; Jean-Luc Menard; Marc Bellavance
Subject: RE: 649.4701- rev C
Attachments: 649.4900 A1 CUTTER ASSY.pdf

Thx Pat
Pls see below

From: Patrick Duval
Sent: Tuesday, November 6, 2018 5:43 PM
To: Caitlin Crooks <ccrooks@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>
Cc: Jason Leroux <jleroux@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>; Marc Bellavance <mbellavance@dartaero.com>
Subject: RE: 649.4701- rev C

Linda,
Here's a quick list of what I will need in order to make my kit to rev C.

649.5111 need some at rev A1 (got some in quarantine) – are these good to use?
649.5112 need some at rev A1 (got some in quarantine) – are these good to use?
649.4811 need some at rev A – WJ>OS – approx. 3wks
649.4816 need some at rev A – WJ>OS – approx. 3wks
649.4813 need some at rev A – WJ>OS – approx. 3wks
649.5214 need some at rev A – Machining>OS- approx. 4-5wks aro
649.5010 need some at rev C1 – Machining>OS- approx. 4-5wks aro
649.4902 need some at rev A – do the 649.5301 and 649.8301 need to be at an older rev? see attached

x 4 each

Rev A1

Also for me to complete the kit from RA173 we will need to add, remove some of the hardware to make it as per rev C.

Sorry for the delay... this is a big mess and I don't what to rush and ship something that's not good.

Pat Duval
QC Coordinator



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041835**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

PO No: PO041835

PO Date: 11/23/18

Due Date: 11/30/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Attention: Lalande, Marc-Andre

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Revised

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	186016	649.4811	Clip Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL- PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed	-	12/10/18	4 pcs	0 pcs	4 pcs	\$11.48/pcs	\$45.92
4	185603	D5583-1	Radius Block : Various STC's Issue P/O to ATG : 1- Anodize Black per MIL- A-8625, Type II, Class 2 as per Dwg. D5583 2- Prime Grey as per Dwg. Certification of Conformity is required.	Firmed	-	12/4/18	18 pcs	0 pcs	18 pcs	\$6.33/pcs	\$113.94

DAS
61
9-89

4X DEC 18 2018

18X NOV 30 2018



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041835**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6		646.3711	Clip Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 646.3700 Rev. A	Firmed	-	12/6/18	12 pcs	0 pcs	12 pcs	\$7.98/pcs	\$95.76

DEC 18 2018

Grand Total: \$255.62

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/30/18 6:56 AM dart.belanger.natasha



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916830

Date: 17-Dec-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
4 ea	Part: 649.4811 Clip Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24211	Rev: E	PO: PO041835 Line: 3
12 ea	Part: 646.3711 Clip Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24214	Rev: A	PO: PO041835 Line: 6
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>17/12/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			

DAS
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